

Work Order ID 75936

\*75936\*

**U/R**

Page 1

November-02-11 10:38:08 AM

Item ID: D3391-021 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd Tube Assembly  
 Start Date: 01/11/2011 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 15/11/2011 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/02 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H U/R

100	Skidtubes	0.00							
*100*									
Skidtubes	Memo	0.00							
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020								

110	BENDING MACHINE - SKIDTUBES	0.00							
*110*									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021								

120	QC5- Inspect part completeness to step on W/O.	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

*DP 11-11-15*

*DP 11-11-15*

*1 Q BE 11-11-15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo 1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>I</u> Identify as D3391-1 2-Deburr	0.00 0.00	<i>SC/SA</i>	<i>u/u/18</i>		<i>1</i>	<i>0</i>		
140 <b>*140*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	<i>SC/SA</i>	<i>u/u/18</i>		<i>1</i>	<i>0</i>		
150 <b>*150*</b> Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE  Memo Drill X1 Aft cap as per Dwg D3391 .1875" dia	0.00 0.00	<i>SC/SA</i>	<i>u/u/22</i>		<i>1</i>	<i>0</i>		

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		SC/brk - 11/11/21		1	6		
170 <b>*170*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		SL 11-11-22					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
<b>*180*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")								
	2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step								
	3-Open tow cap holes to .208" as per Dwg D3391								
	4-Open Tow Ring hole to .640" as per Dwg D3391								
	5- open float bag holes 0.328" and counter sink as per dwg D3391								
	6-Deburr & Scribe Batch number Inside aft end.								
	7-Transfer drill D3391-021 with D3391-023								
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

*DP 11-11-22*

*DP 11-11-28*

*11 11 30 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*200*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									
220	Skidtubes	0.00							
<b>*220*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>117870</u> exp. date: <u>02/12</u> cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								

*OK 11/12/01*

*11 - 12 - 01 (1)*

*OK 11/12/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC5- Inspect part completeness to step on W/O	0.00							
<b>*230*</b>									
QC	Memo	0.00							
Quality Control									

235	Pressure Wash per QSI005 4.3	0.00							
<b>*235*</b>									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:40 OVEN TEMPERATURE: 3200F FINISH TIME: 12:10								

W118439

11 - 12 - 02 ①

1X Ø m/p 11/12/05

1X Ø m/p 11/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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November-02-11 10:38:08 AM

**Item ID:** D3391-021  
**Revision ID:**  
**Item Name:** Fwd Tube Assembly

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

**Start Date:** 01/11/2011    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 15/11/2011      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*ND1\*

Stop \*NR2\*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>wlo</u>	0.00	D412-742-043/1375909			1	0	42	11/12/05
<b>*260*</b>			<del>1376400</del>						
Packaging	Memo	0.00							
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

11/12/19 *[Signature]*

*MF*  
11-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



## November-02-11 10:38:13 AM

Page 1

**\*75936\***

**\*D3391-021\***

**Required Date: 15/11/2011**

**Required Qty: 1.00**

**Comments:**

IPP A05.09.13	New issue	KJ/JLM
IPP B06.02.10	Dwg rev.D ecn 773	EC
IPP C06.05.02	Added inspections	EC
IPP D 07.03.13	rev F dwg	EC
IPP E 07.11.07	revG dwg ecn1053P	EC verified by: DD
IPP Rev:f	ECN 1056 07-11-12	DD verified by: EC
IPP Rev:G	08-09-08 new process (ecn 08-510)	DD verified by:EC
IPP Rev:H	08-09-10 revH as per dwg	DD verified by:EC
IPP Rev J	09.02.02 added hardware	EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047		Manufactured	No			100	Each	8.0000	1	1			
<b>*D6013-047*</b> Skidtube Material													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		8							
				26547		8							
D3670-4-200		Manufactured	No			220	Each	128.0000	4				
<b>*D3670-4-200*</b> SPACER													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		36							
				71850		36							
				LG001		92							
				72851		92							
D3401-041		Manufactured	No			255	Each	2.0000	1	1			
<b>*D3401-041*</b> Tow Cap Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP007		2							
				71352		2							

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 75936

**\*75936\***

Parent Item: D3391-021

**\*D3391-021\***

Parent Item Name: Fwd Tube Assembly

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

255

Each

20.0000

1

1

**\*D3564-13\***

Wearshoe

\*\*

B76220? (x1) 11/12/08

D4095-051

Location

Loc Qty

Loc Code

FP001

19

72850

1

73323

18

FP017

1

71594

1

D3566-13

Manufactured No

255

Each

34.0000

1

1

**\*D3566-13\***

Gasket

\*\*

N/A

11.12.05

N/A

Location

Loc Qty

Loc Code

FP

29

73322

29

FP014

5

68341

1

72149

4

AN960C10L

NAS1149C0332

Purchased

No

255

Each

0.0000

10

10

**\*AN960C10L \***

washer

\*\*

M119736 (x10) 11/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

255 Each 2,389.000 10 10

\*AN3C4A\*

BOLT

\*\*

HL 11/12/05

## Location

## Loc Qty

## Loc Code

ST350

2389

117313

2

117688

5

117872

22

118112

16

118451

2

118706

364

118838

978

119328

1000

D3672-1 Manufactured No

255 Each 696.0000 4 4

\*D3672-1\*

Phenolic Washer

\*\*

HL 11/18/05

## Location

## Loc Qty

## Loc Code

FP-A

432

52505

0

66821

432

ST074

264

72229

264

AEIS-1032-130 Purchased No

255 Each 0.0000 2 2

\*AFI S-1032-130\*

INSERT

ALS7-1032-130

\*\*

M119530 (v2) HL 11/12/05

AEIS-1032-225

Purchased No

255 Each 0.0000 10 10

\*AFI S-1032-225\*

INSERT

\*\*

M118966 (v1d) HL 11/12/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

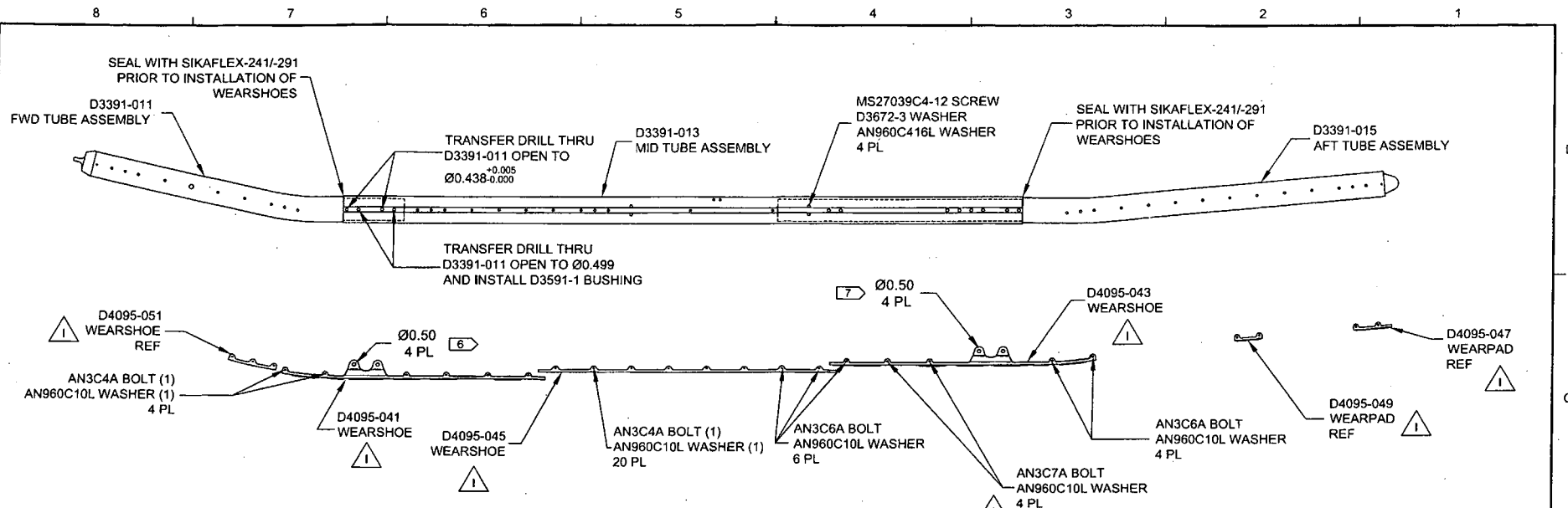
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





# **D3391-041 ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 95936 M.L.J. 11/11/07

RELEASED  
2011-11-04  
ECN# 11-662

## **D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

## **GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
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**DART AEROSPACE USA, INC**  
KENT, WA

DRAWING NO. D3391 REV. 1 SHEET 1 OF 8

TITLE 412 FLOAT SKIDTUBE SCALE NTS

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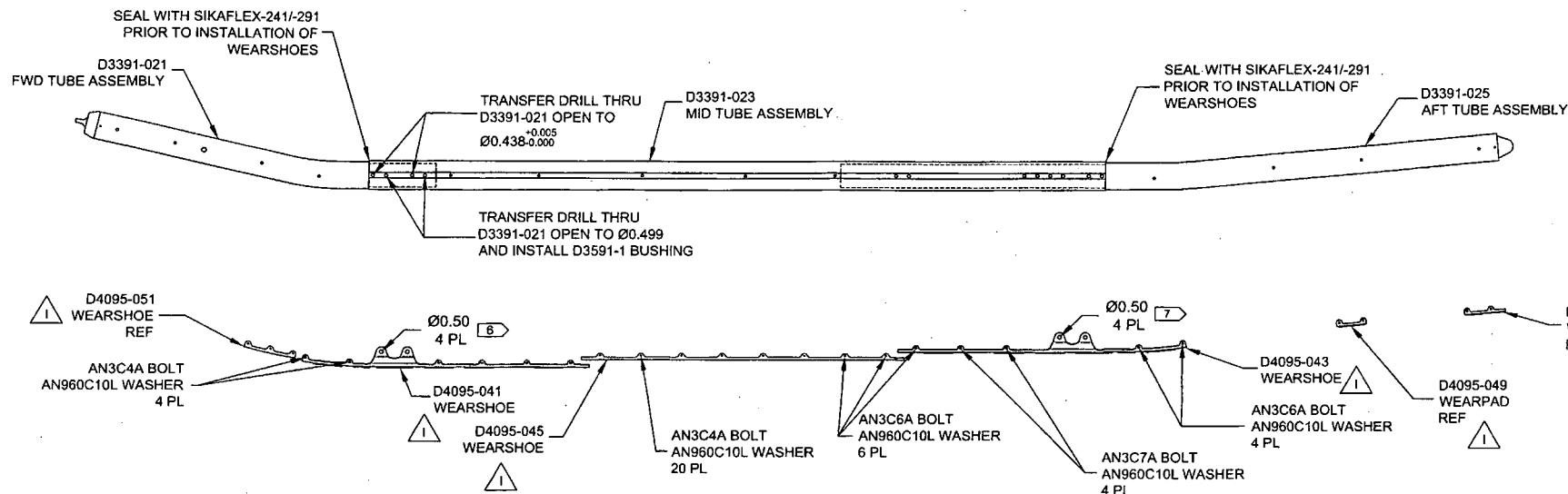
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# **D3391-043 ASSEMBLY**



## **D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
-043		
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

## **GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"  
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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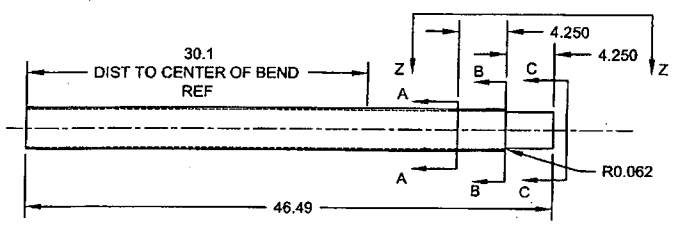
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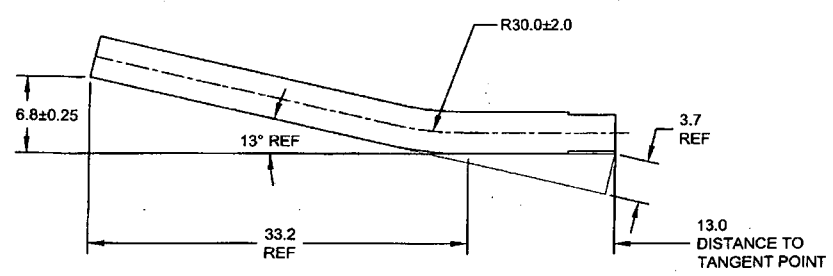
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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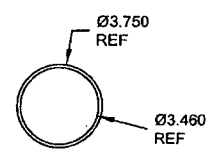
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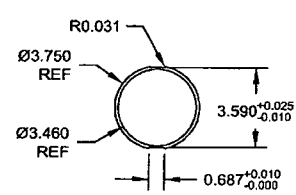
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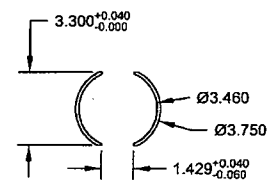
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



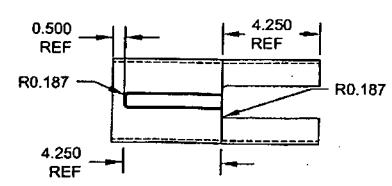
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**SECTION B-B**  
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**SECTION C-C**  
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**VIEW Z-Z**  
SCALE 2X

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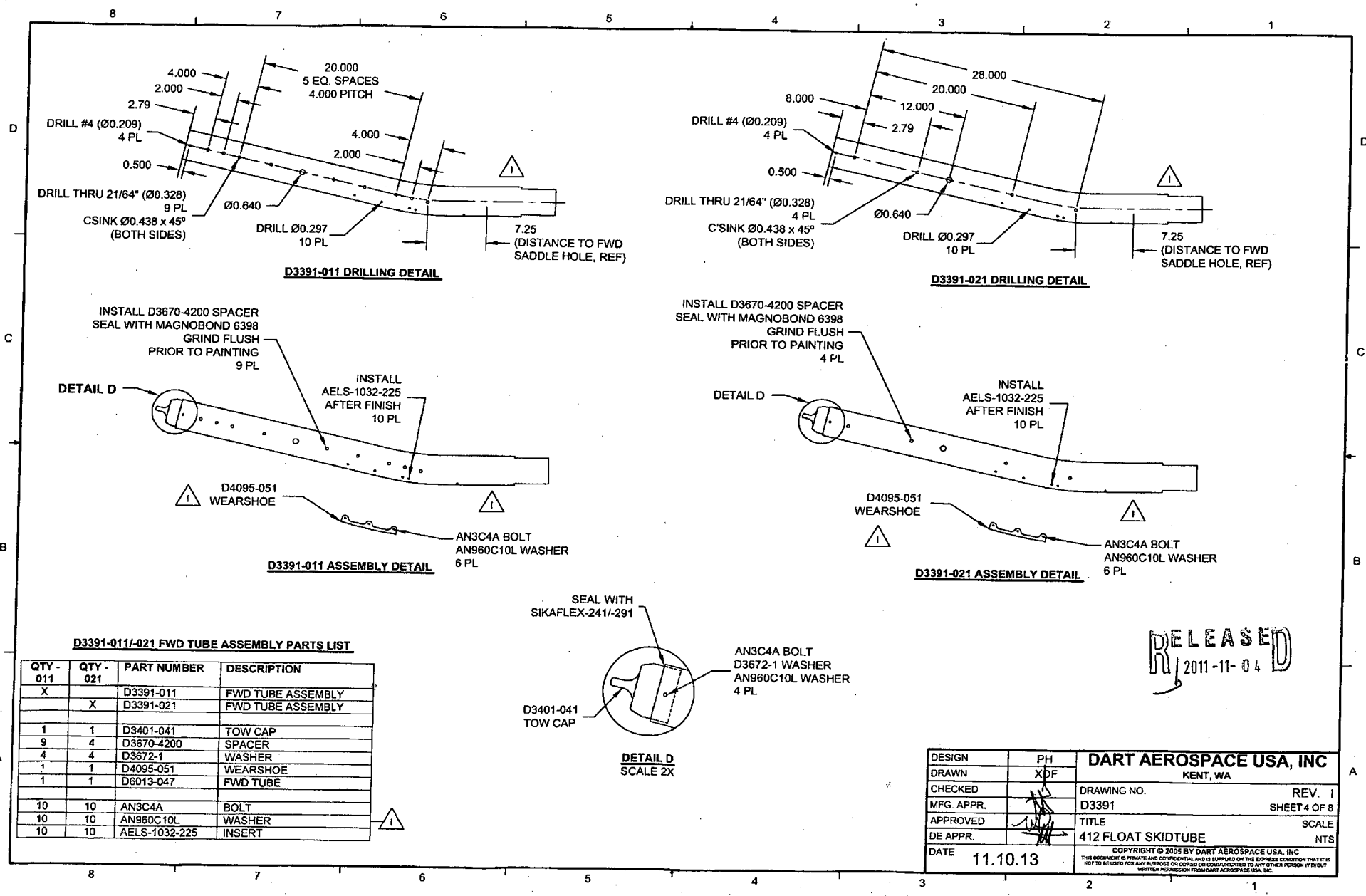
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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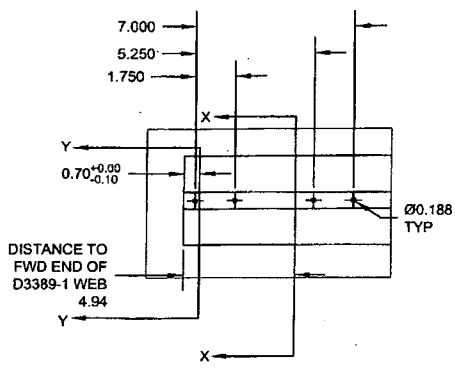
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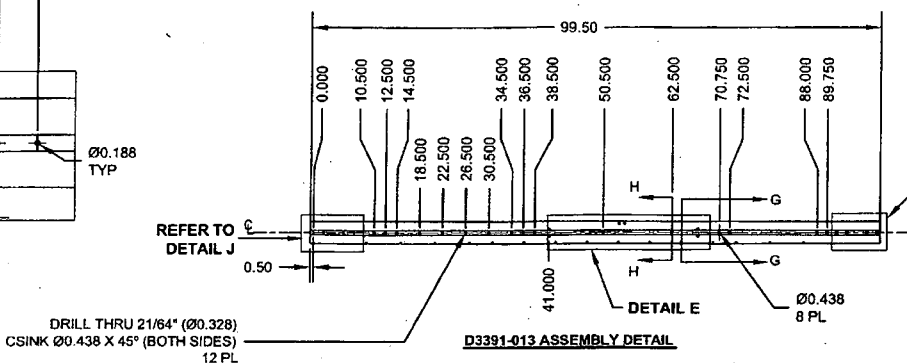
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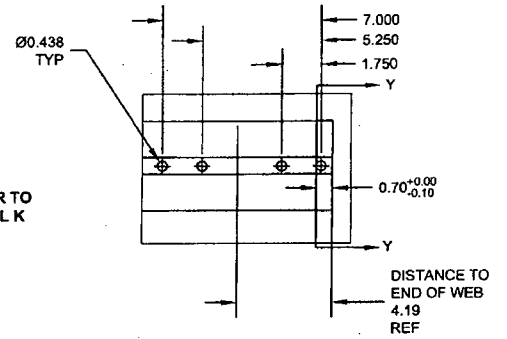
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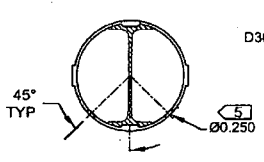
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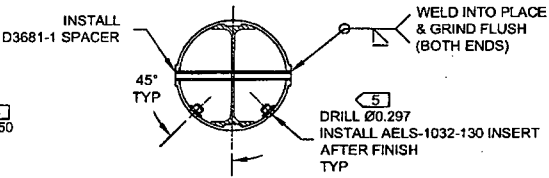
D3391-013 ASSEMBLY DETAIL



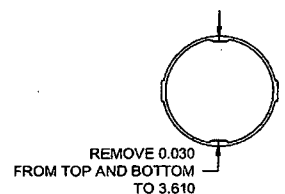
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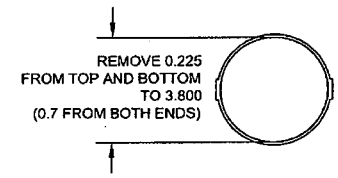
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SECTION H-H  
SCALE 5X



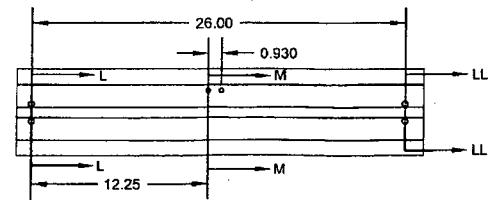
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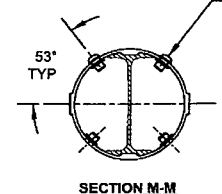
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

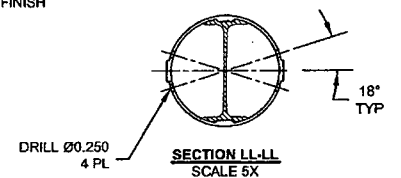
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E  
SCALE NONE

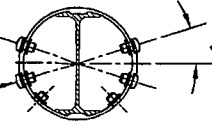


SECTION M-M  
SCALE 5X



SECTION LL-LL  
SCALE 5X

DRILL Ø0.391  
INSTALL ALS4-428-165 INSERT  
MS27039C4-08 SCREW  
D3672-3 WASHER  
AN960C416L WASHER  
AFTER FINISH  
4 PL



SECTION L-L  
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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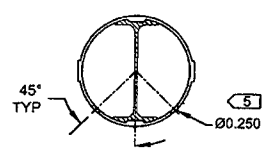
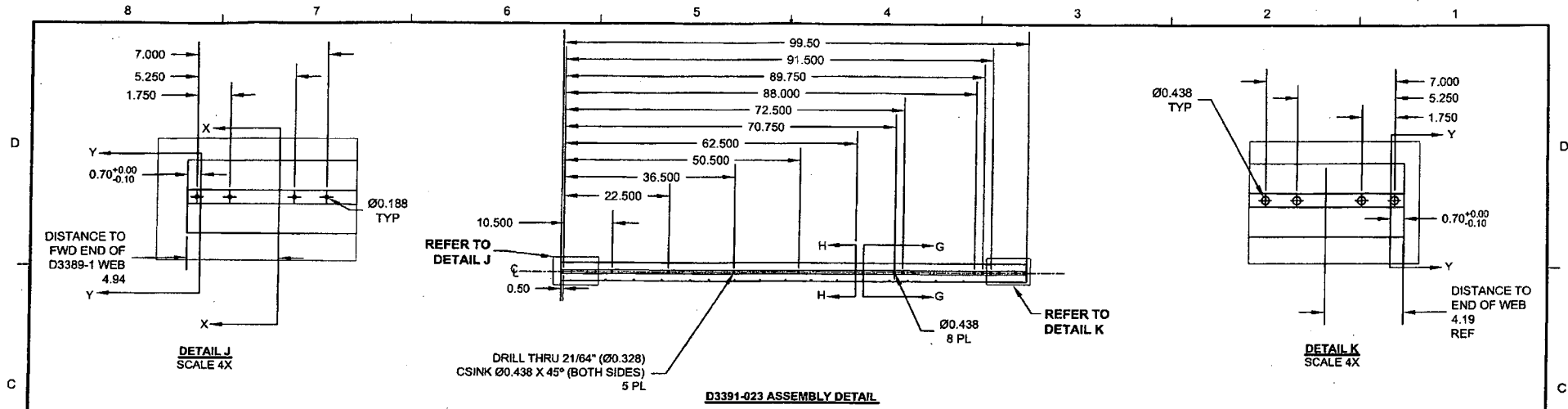
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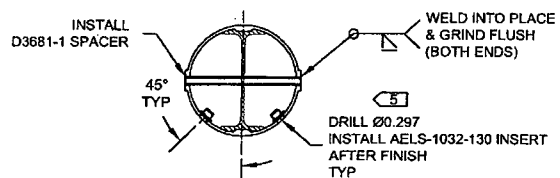
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

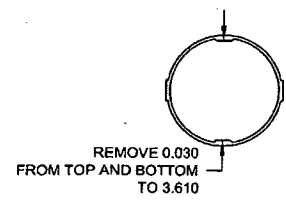
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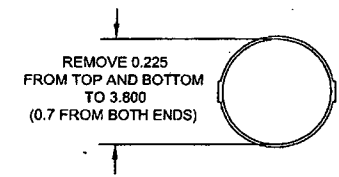
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SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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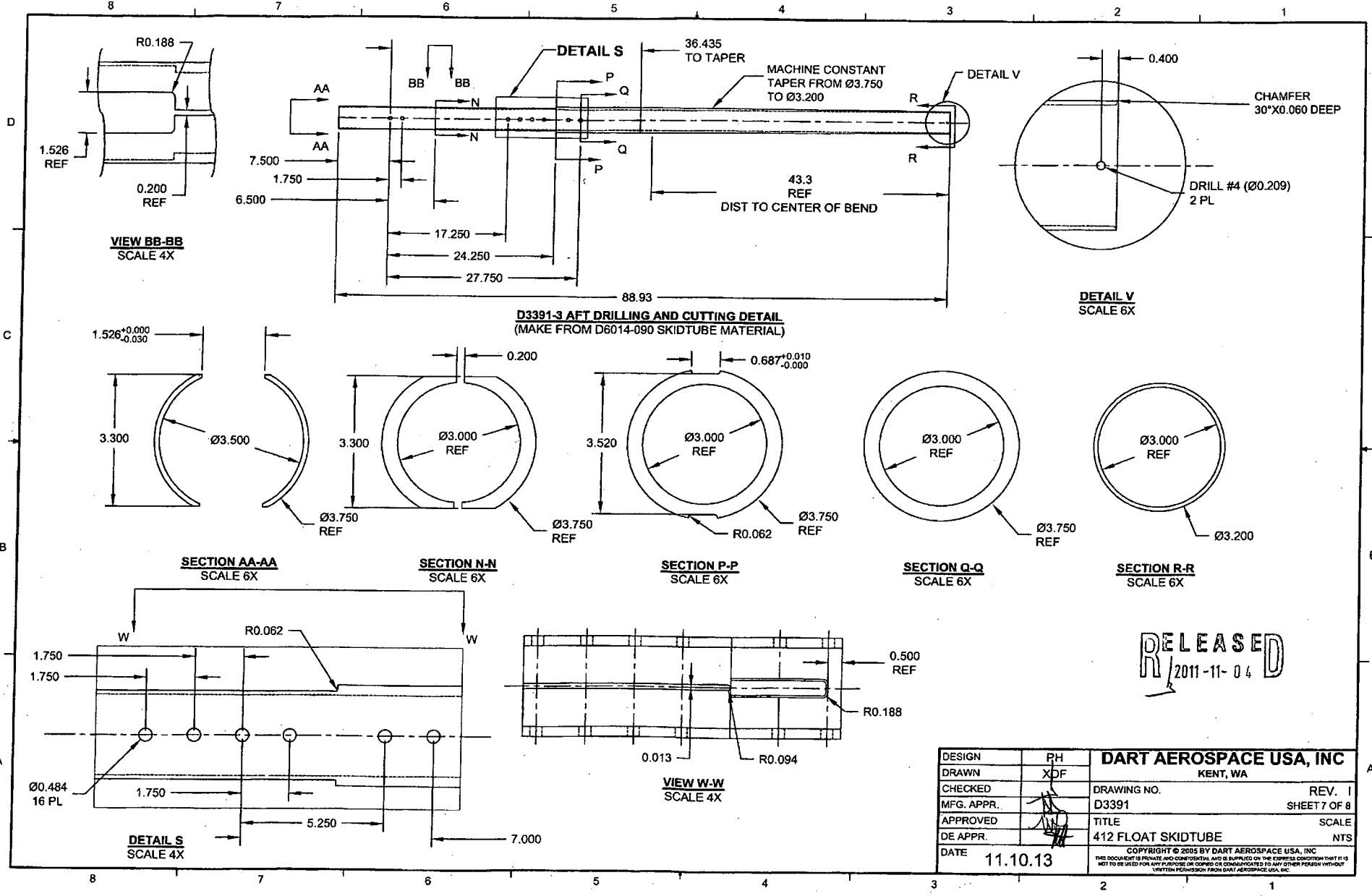
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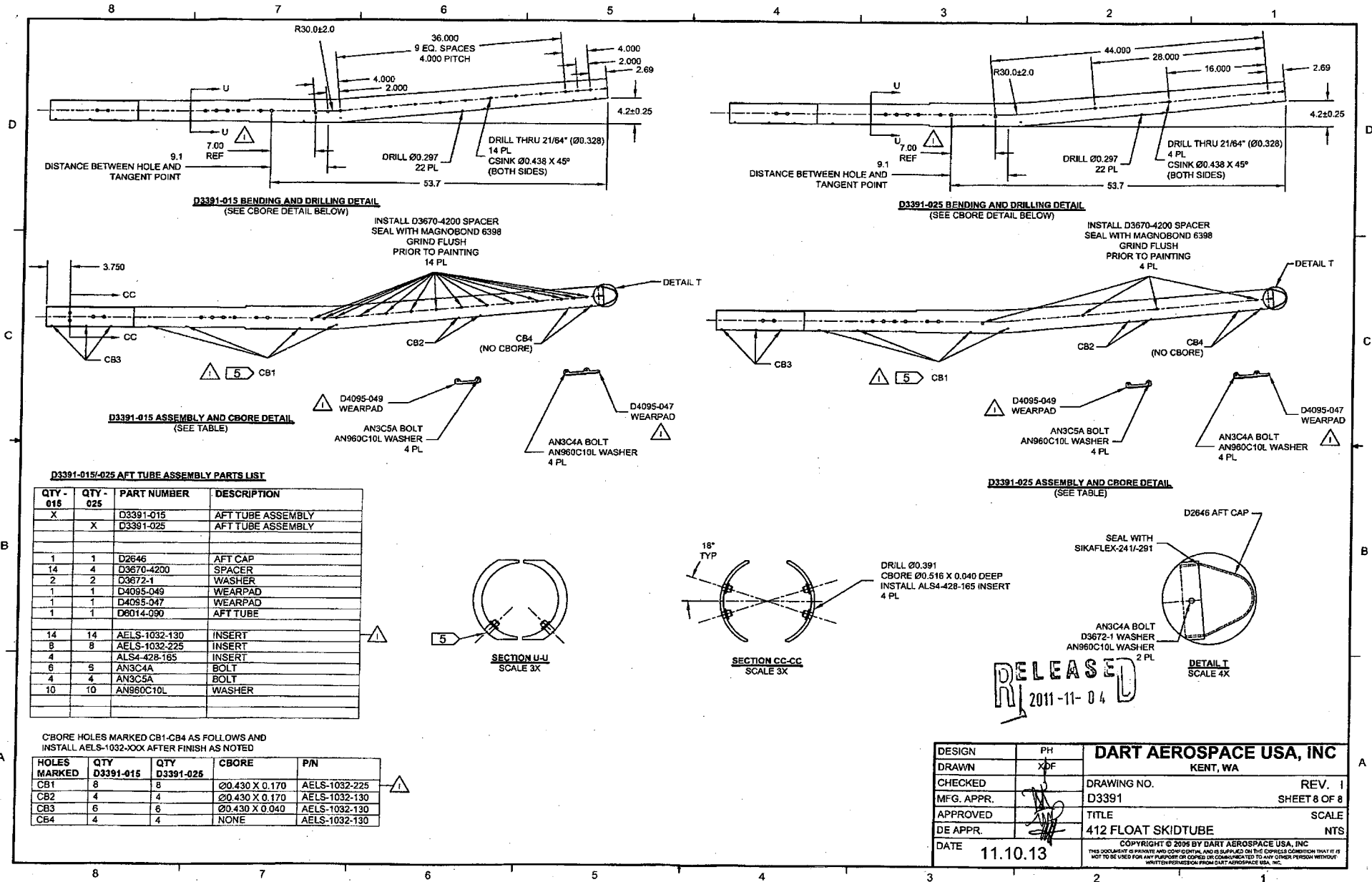
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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